

Work Order ID 66153 -2

Monday, February 07, 2011 11:18:00 AM

Page 1

Item ID: D3564-9

Accept

Revision ID:

Item Name: Wearshoe

Setup Start

Stop

Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MUF

Date: 11-02-07

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

304 063

B 11-3-8

(20)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B 11-2-8

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

11-02-08 (20)

Work Order ID 66153

Monday, February 07, 2011 11:18:00 AM



Page 2

Item ID: D3564-9

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Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 Form Joggle as per Dwg D3564 on brake using Jig DT 8157

SP 11/02/09

20

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

11 02 08 (20)

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
M116876 Weld hardcoat as per Dwg D3564

11-2-28 (48)

Work Order ID 66153

Monday, February 07, 2011 11:18:00 AM

Page 3

Item ID: D3564-9

Revision ID:

Item Name: Wearshoe

Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Substop
11/03/01

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

80

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

320°F

OVEN TEMPERATURE:

9:00

FINISH TIME:

9:30

M115128

(8X) m-1 11/03/01

Work Order ID 66153

Monday, February 07, 2011 11:18:00 AM

Page 4



Item ID: D3564-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 2/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 & M 11/03/01

200

Identify as per dwg & Stock Location: FP19

0.00



Packaging

Memo

0.00

Packaging

8x m/f 11/03/01

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/02 DJ

CL 11/03/02

Picklist Print

Monday, February 07, 2011 11:17:57 AM

Page 1

Work Order ID: 66153

Parent Item: D3564-9

Parent Item Name: Wearshoe



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

222.2800

1.41

29.68421



304/316 Sheet .063



18-11-2-8

Location

Loc Qty

Loc Code

MAT

222.28

111323

0

116623

222.28

116623



DART AEROSPACE LTD		Work Order: 66153
Description: Wearshoe		Part Number: D3564-9
Inspection Dwg: D3564	Rev: D	Page 1 of 1

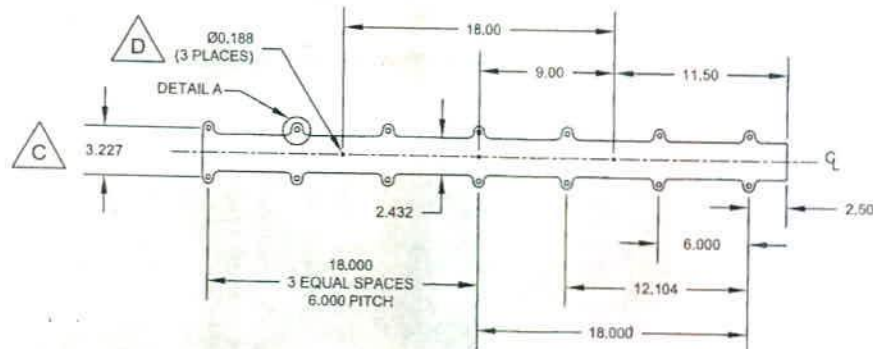
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

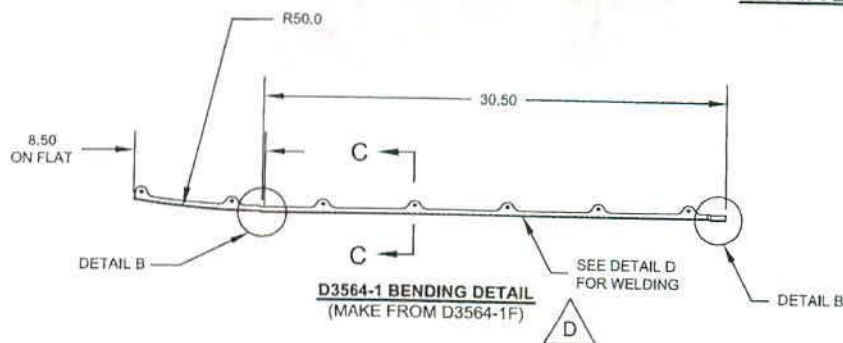
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.224	✓		V HB02	
2.432	+/-0.010	2.439	✗		V	
2.50	+/-0.030	2.500	✓		V	
6.000	+/-0.010	6.000	✗		T HB01	
12.104	+/-0.010	12.104	✓		T	
18.000	+/-0.010	18.00	✗		T	
18.000	+/-0.010	18.00	✓		T	
18.00	+/-0.030	18.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
0.300 x 0.300	+/-0.010	0.301 x 0.303	✗		V	
Ø0.188	+0.005/-0.001	0.189	✗		V	
R0.375	+/-0.010	0.375	✗		R.G.	
0.063	+/-0.010	0.059	✗		V	

Measured by: B	Audited by: [Signature]	Prototype Approval: N/A
Date: 11-2-8	Date: 11-02-08	Date: N/A

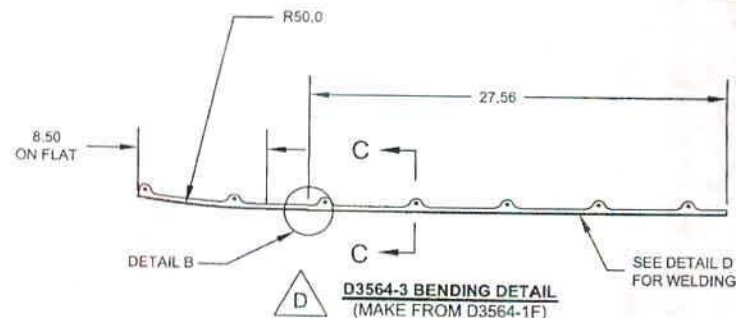
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD [Signature]	[Signature]



D3564-1F FLAT PATTERN



**D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

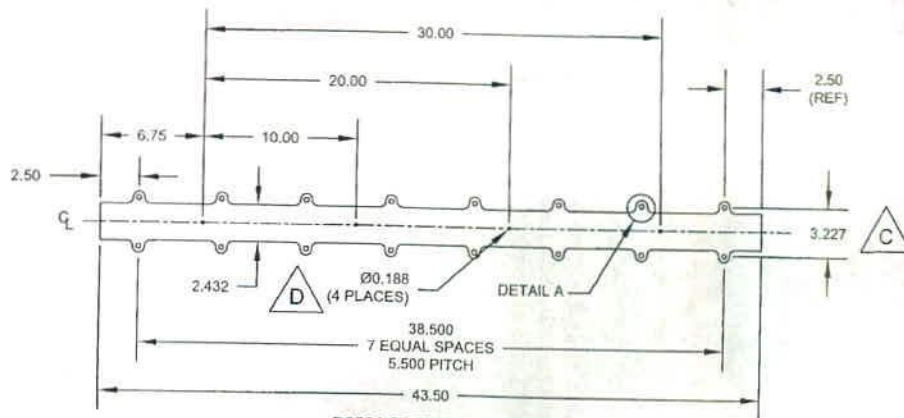
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
	C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
	B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
	A	NEW ISSUE	PH	06.12.18
REV.		DESCRIPTION		DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. D	
MFG. APPR.	PH	D3564	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	WEARSHOE	1:8	
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

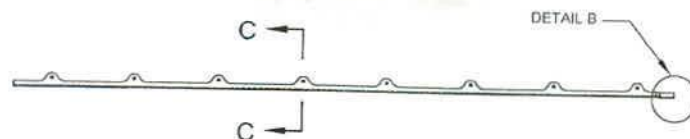
RELEASED

07.09.04

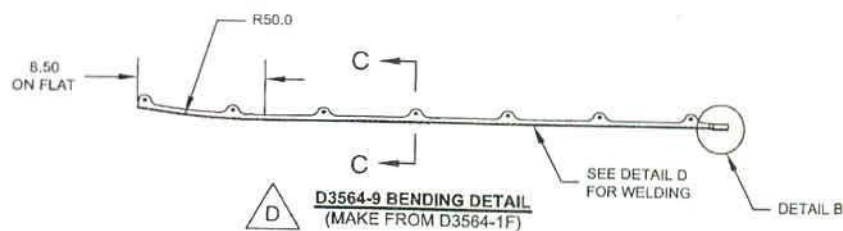
#66153



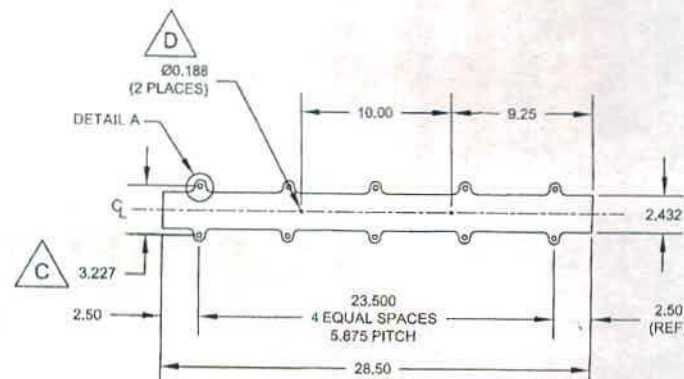
D3564-5F FLAT PATTERN



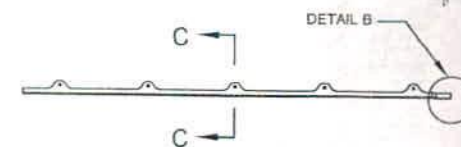
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



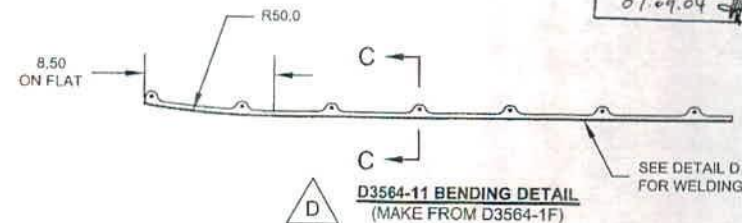
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



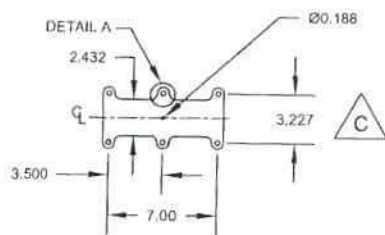
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



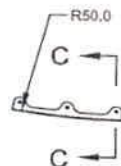
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

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07.09.04

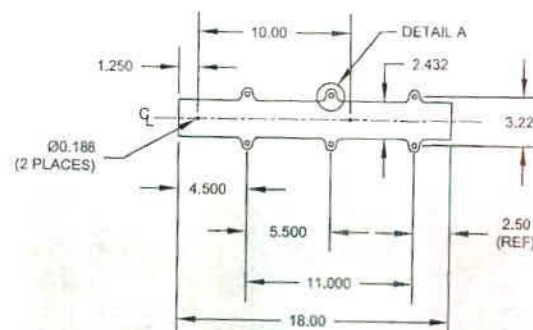
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DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1/8
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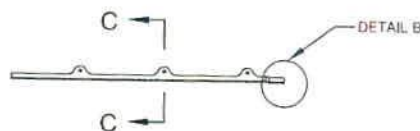
D3564-13F FLAT PATTERN



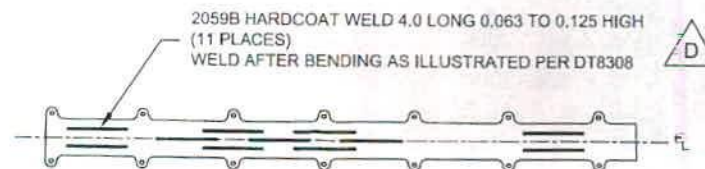
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



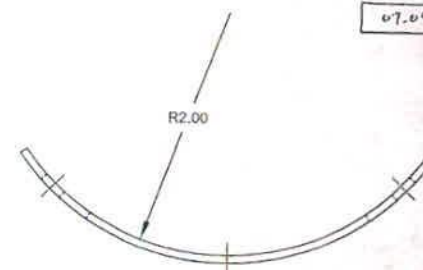
D3564-15F FLAT PATTERN



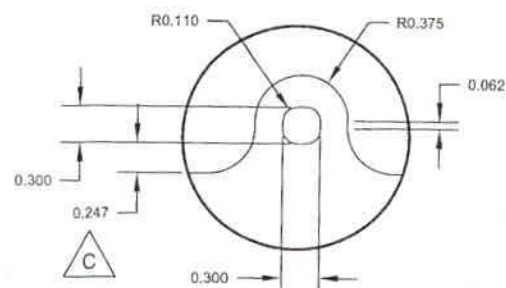
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



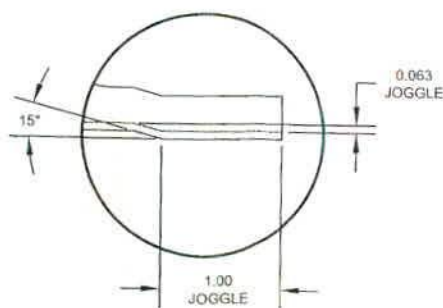
DETAIL D
(D3564-15/3/9/11 WELDING DETAIL)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:1
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07.09.04

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